Dart Aerospace Ltd.

SPLIT

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: MOUNTING LUG
Job Number	: 30993		
Estimate Number	: 10256		
P.O. Number	: N/A	**Part Number**	: D22303
This Issue	: 05/03/2007 **S.O. No.** : N/A	**Drawing Number**	: D2230 REV F
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 01/03/2007 **Type** : MACHINED PARTS	**Drawing Revision**	: F
Previous Run	: 30545	**Material**	: N/A

Due Date : 03/12/2007   **Qty:** 1,000 **Um:** Each

Written By :

Checked & Approved By :

Comment : Est D 00.05.18   Added inspection level 8, and removed P/O for powder coat   EC

Additional Product

Job Number: ||||||||||||||||

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	D2423	Lug Extrusion

Comment: Qty.: 0.0717 f(s)/Unit   **Total :** 71.7150 f(s)
Lug Extrusion
D2423
Batch: 30062

2.0	BAND SAW	BAND SAW

Comment: Band Saw
Cut D2423 extrusion to 0.82"
Batch: 30062

3.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O BLKT00001   CL07/03/08   (1000)
Possible Supplier : Metec
Machine per Drwg D2230 Rev. F

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect for transit damage   P- 7/6/05   (124)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	**Drawing Name:** MOUNTING LUG
Job Number: 30993	**Part Number:** D22303

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	*07-06-15* (124) *counted*
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	N/A
	Tumble and deburr rough edges after tumbling	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1	*counted*
	Acid etch and Alodine as per QSI 005 4.1	07-06-18 (124)
8.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	*07-06-18*
9.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING	M 104144 (124)
	Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3	BR/M 07-06-18
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COATINSPECT POWDER COAT	07/06/18 (124)
11.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	(122)
	Identify and Stock	
	Location: St 480	7/6/18 SQ 124
12.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(124)
		07/06/19

Job Completion

07-06-19

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2230	SHEET 1 OF 2
DATE		TITLE	SCALE
99.12.13		MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 DS

4.450

SYMMETRIC ABOUT CL

MACHINE TO SIZE

0.273

R0.125

0.306

/F\ R1.200

D2230-1

1.91 (REF)

0.345

0.400

0.250

MACHINE TO SIZE

0.735 (REF)

ENGRAVE PART NUMBER
TO DEPTH OF 0.010±0.005
IN THIS LOCATION, WITH TOOL
TIP RADIUS OF 0.015±0.005

R0.38

3.700

0.375

R0.38 (REF)

$\varnothing 0.257 \, ^{+0.005}_{0.000}$ (TYP)

0.750

D2230-1
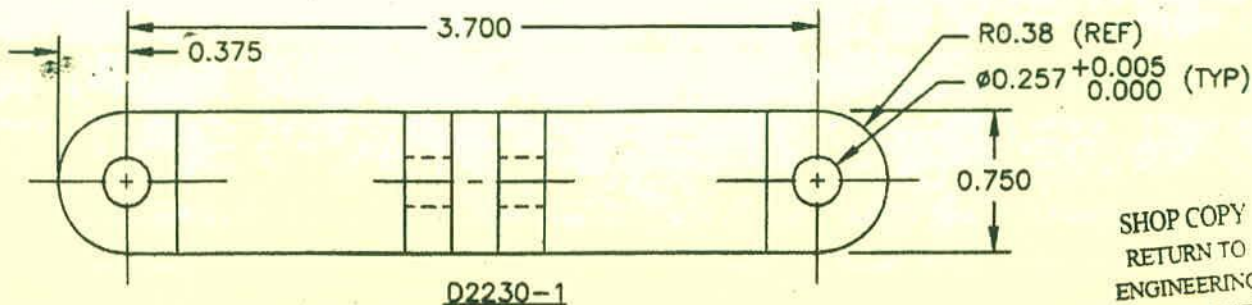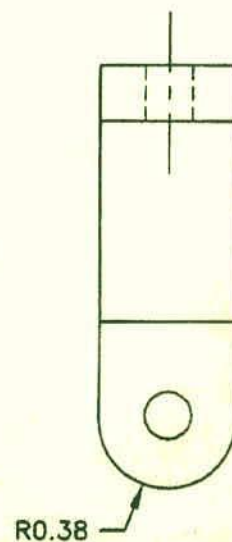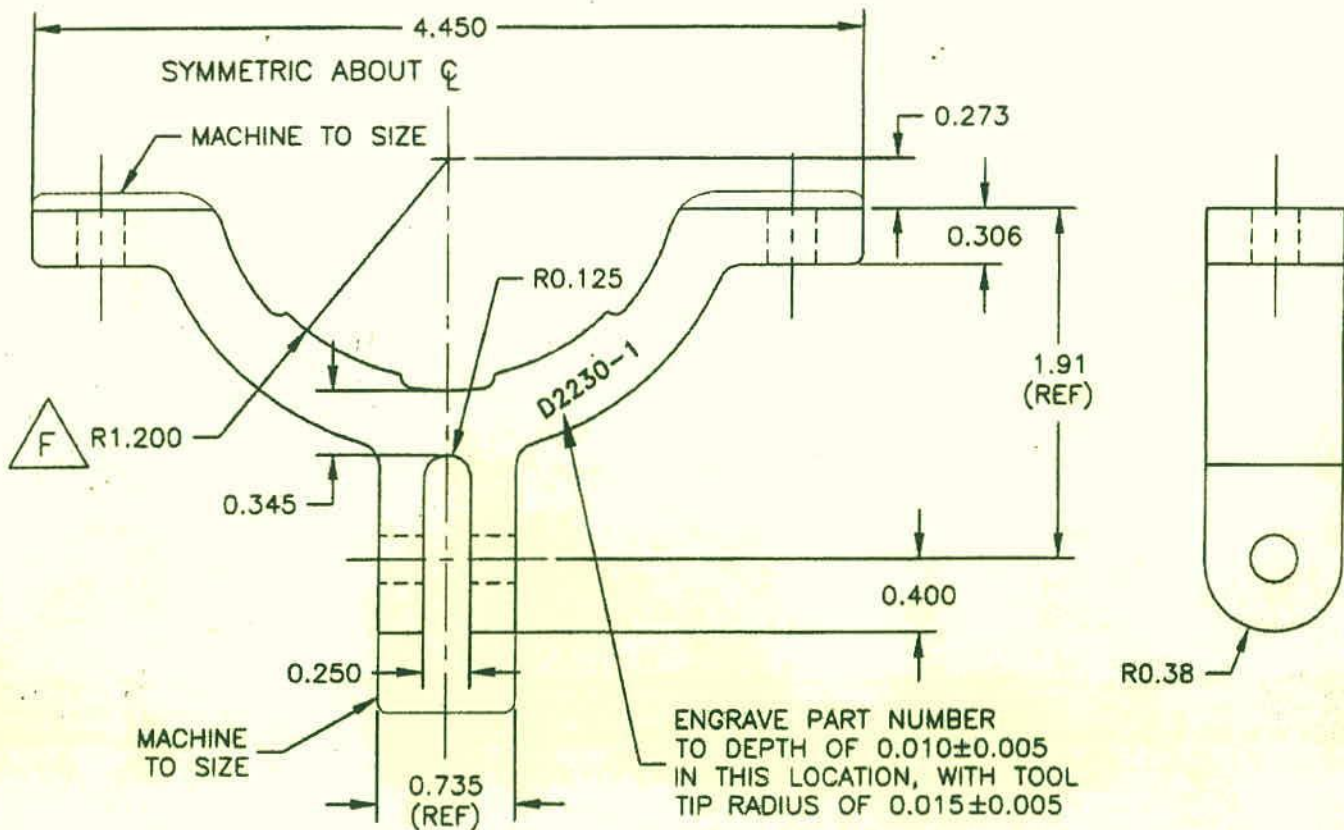
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
        POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
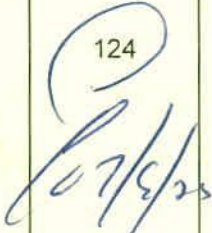
METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **15946**
Date: Jun 15, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7

Order No.: BLKT00001		**Sold By:**	
Shipped By: our truck		**Ship Date:** Jun 15, 2007	

Description		Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug	Each	400		
D2230-3	Mounting Lug	Each	1,000	124	846
D2731-3	Mounting Lug	Each	50		
D2731-7	Mounting Lug	Each	100		50
D3235-1	Mounting Lug	Each	500		250
D3394-1	Mounting Lug	Each	100		
D3394-3	Mounting Lug	Each	200		100

Received by _____

Thank you for your order!

METEC METAL TECHNOLOGY INC.

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
124	D2230-3	Lug B30993	BLKT00001

MATERIAL: supplied by DART   D2423   B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, June 14, 2007